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D5669-041
Job Sheet 196028



Part No: D5669-041

Job Qty: 1 pcs

Part Name: Long Basket Lid Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/5/19

Job Tracking No:

Created By: Linda Lacelle

Due Date: 6/28/19

Description:

Type: Stock

Note: TBD DWG D5669 REV.A IPP REV:A 18.07.23 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	6/28/19	6/28/19	0.00	6.67	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs	6/28/19	6/28/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1 pcs	6/28/19	6/28/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
130 Powdercoat - 2 White GI(S)- B4B <i>M1 75-439</i>	1 pcs	6/28/19	0.00 0.40	Powdercoat - 1 - B4B		
				Powdercoat - 2 - B4B		
				Powdercoat - 3 - B4B		<i>BL 19-7-32</i>
				Powdercoat - 4 - B4B		
135 QC 3	1 pcs	6/28/19	0.00 0.00	QC 3 - 10		
				QC 3 - 13		
				QC 3 - 15		<i>W 19-8-1</i>
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40		
				QC 3 - 19		
				QC 3 - 43		
				QC 3 - 24		
140 Handfinish - 4-1-Assembly- B4B	1 pcs	6/28/19	0.00 0.80	Handfinish - 4 - 1 - B4B		<i>W 19-8-6</i>
				Handfinish - 4 - 10 - B4B		
				Handfinish - 4 - 11 - B4B		
				Handfinish - 4 - 12 - B4B		
				Handfinish - 4 - 13 - B4B		
				Handfinish - 4 - 14 - B4B		
				Handfinish - 4 - 15 - B4B		
				Handfinish - 4 - 2 - B4B		
				Handfinish - 4 - 3 - B4B		
				Handfinish - 4 - 4 - B4B		
				Handfinish - 4 - 5 - B4B		
				Handfinish - 4 - 6 - B4B		
				Handfinish - 4 - 7 - B4B		
				Handfinish - 4 - 8 - B4B		
				Handfinish - 4 - 9 - B4B		
150 QC 5	1 pcs	6/28/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		<i>00-6</i>
				QC 5 - 18		<i>81</i>
				QC 5 - 19		<i>DAS</i>
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		

DAS
15
9-89

				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
160	Packaging 3-1 - Stock - B4B	1	6/28/19	0.00 0.00	Packaging 3 - 1 - B4B
	pcs				Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
170	QC 21 - SA	1	6/28/19	0.00 0.00	QC 21 - SA - 21
	pcs				QC 21 - SA - 70
					QC 21 - SA - 53

DAS
19
9-00

DAS
21 AUG 07 2019
9-00

Part Op **100** - 1- Assemble ribs , weld as per dwg D5669 using DT9607A 2- Weld hinge (3) and Mounting brackets as per dwg
 Descriptions: D3914 ***Visual inspect before welding mesh*** 3- Cut lid mesh as per dwg 4- Tack weld mesh on basket as per dwg
 D5669 ***Cut out mesh where label plate goes in center off basket lid as per dwg. Make sure to place mesh correctly on
 lid, check with label plate before tacking mesh*** ***CUT OUT MESH ON TOP OF D2581 1.5" HIGH*** ***DOUBLE
 CHECK WITH A HANDLE*** 5- *****SCRIBE ID AS PER DWG NOTE 6 ON SHEET 1****
110 - (QC9- Inspect visual per QSI004- Fusion Welds)
120 - (QC5- Inspect part completeness to step on W/O) *****SCRIBE ID AS PER DWG NOTE 6 ON SHEET 1****
130 - *** Mask holes as per note 9, sides of hinge and note 11 prior to powdercoat*** START TIME: _____ OVEN
 TEMPERATURE: _____ FINISH TIME: _____
135 - (QC3- Inspect Part Finish)
140 - (Assemble as per dwg) 1- Assemble as per dwg 2- Mask data plate and apply wing walk on outside surface of mesh
 as per dwg and QSI Wing Walk batch: 5185142
150 - (QC5- Inspect part completeness to step on W/O)
160 - (Identify as per dwg & Stock Location: _____)
170 - QC21 (QC21- Final Inspection - Work Order Release)

010357

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5188852
D3914-1	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5189131
D4016-3	Hinge Half, Lid	3 pcs (3 ea)	100-Large Fab - Basket - 1	5110937
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea)	100-Large Fab - Basket - 1	5183329
D5670-1	Rib	4 pcs (4 ea)	100-Large Fab - Basket - 1	51817830
D5670-3	Rib	9 pcs (9 ea)	100-Large Fab - Basket - 1	518178017
D5672-1	Data Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5133197
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	5181090
AN3-14A	Bolt	4 Ea (4 ea)	140-Handfinish - 4-1-Assembly-B4B	5161920
AN3-16A	Bolt	2 Ea (2 ea)	140-Handfinish - 4-1-Assembly-B4B	5157471.2
AN5-17A	Bolt	2 Ea (2 ea)	140-Handfinish - 4-1-Assembly-B4B	5198631
D2530	Handle Weldment	1 pcs (1 ea)	140-Handfinish - 4-1-Assembly-B4B	X 203312
D2535	Spring	2 pcs (2 ea)	140-Handfinish - 4-1-Assembly-B4B	515403.1
D2537 PD	Bushing	2 pcs (2 ea)	140-Handfinish - 4-1-Assembly-B4B	5123161
D3953-17	Gas Spring Spacer	2 pcs (2 ea)	140-Handfinish - 4-1-Assembly-B4B	5196145
D3953-19	Gas Spring Bracket	2 pcs (2 ea)	140-Handfinish - 4-1-Assembly-B4B	5184417
MS21042L3	Nut	6 Ea (6 ea)	140-Handfinish - 4-1-Assembly-B4B	5194496
MS21042L5	Nut	2 Ea (2 ea)	140-Handfinish - 4-1-Assembly-B4B	5176461
NAS1149F0332P	Washer	8 Ea (8 ea)	140-Handfinish - 4-1-Assembly-B4B	5158976
NAS1149F0563P	Washer	2 Ea (2 ea)	140-Handfinish - 4-1-Assembly-B4B	5200164

Job Allocations

011189

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	0	0
	D3914-1	2	8	0
	D4016-3	3	33	0
	D4035-043	2	12	0
	D5670-1	4	0	0
	D5670-3	9	3	0
	D5672-1	1	3	0
140-Handfinish - 4-1-Assembly-B4B	M304EX0.75-16F	32	284	0
	AN3-14A	4	232	0
	AN3-16A	2	169	0
	AN5-17A	2	132	0
	D2530	1	11	0
	D2535	2	202	0
	D2537	2	110	0
	D3953-17	2	16	0
	D3953-19	2	28	0
	MS21042L3	6	1,840	0
	MS21042L5	2	701	0
	NAS1149F0332P	8	3,209	0
	NAS1149F0563P	2	367	0

Part Specifications

Specifications could not be found.



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Container No: S190217



Part: D5669-041

Job No: 196028

Serial No/Batch: S190217

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 06/13/19